

Work Order ID 53644

November 11, 2009 1:25:48 PM



Page 1

Item ID: D3825-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 11/11/09 Start Qty: 2.00



Cust Item ID:

Required Date: 11/12/09 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3825

Rev A

0.00

Q

*Custom made for DS19473
conversion*

100



Large Fab

0.00

Large Fab

Memo

Large Fab

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825 ** DS19473 E*

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D3327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R S.S. Rod Batch: *M109213*

7- grind bushing weld flush where indicated on dwg D3825 *✓*

8- deburr if necessary *✓*

SM 09/11/12

(2x)

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Page 2

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Stop



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Start Date: 11/11/09 Start Qty: 2.00



Cust Item ID:

Required Date: 11/12/09 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

PD 09.11.12

140 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

2

09.11.13

150 Identify as per dwg & Stock Location: Basket 0.00



Packaging Memo 0.00

Packaging

PD 09.11.16 (2)

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Page 3

Item ID: D3825-041

Accept

Setup Start

Revision ID: A

Stop

Item Name: Rib Assembly (Basket End)

Start Date: 11/11/09 Start Qty: 2.00

Cust Item ID:

Required Date: 11/12/09 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/16
MF
09-11-16

Picklist Print

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Page 1

Work Order ID: 53644

Parent Item: D3825-041RevA

Parent Item Name: Rib Assembly (Basket End)

Start Date: 11/11/09

Required Date: 11/12/09

Comments: IPP RevA: revise process 09.11.11 DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2327-3RevD

Manufactured

No

100

Each

32.0000

2.0000



Spacer Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

44274

13

44365

9

51126

10

N/A

D3759-1RevA

Manufactured

No

100

Each

66.0000

2.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

66

51473

30

53442

36

2x 8/09/11/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 11, 2009 1:25:47 PM

Work Order ID: 53644



Parent Item: D3825-041RevA



Parent Item Name: Rib Assembly (Basket End)


Start Date: 11/11/09

Required Date: 11/12/09

Comments: IPP RevA: revise process 09.11.11 DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	479.3370	4.4737			
												
304 SQ Tube .75x.75x.065W												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	473.6842	
113082	473.6842	
Main Warehouse		
WA	5.6527947	
112398	5.6527947	

44737 *BY 09/11/12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

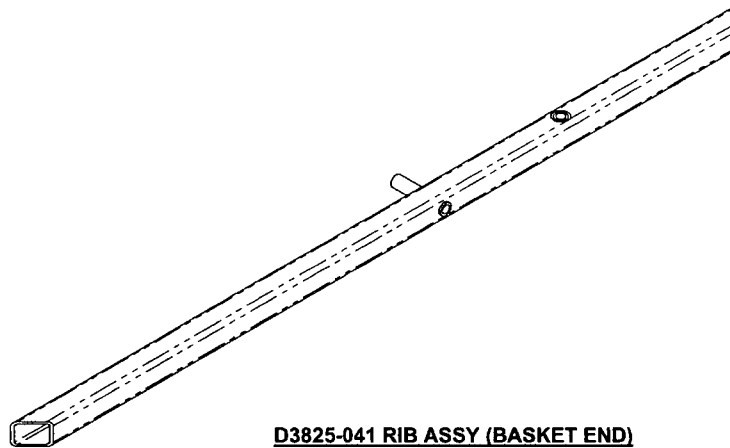
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB

4/0 53644



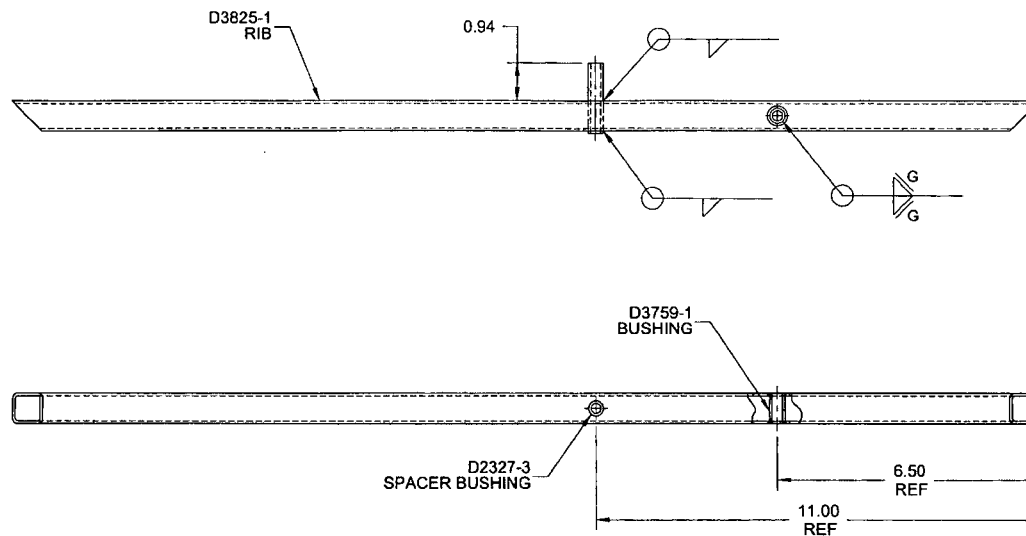
D3825-041 RIB ASSY (BASKET END)

RELEASED
08/11/18/MB

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.22 lbs
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	08.09.23
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3825 TITLE RIB ASSY (BASKET END)		REV. A	
DRAWN			SHEET 1 OF 3	
CHECKED			SCALE	
MFG. APPR.			NTS	
APPROVED				
DE APPR.				
DATE	08.09.23		<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O 53644

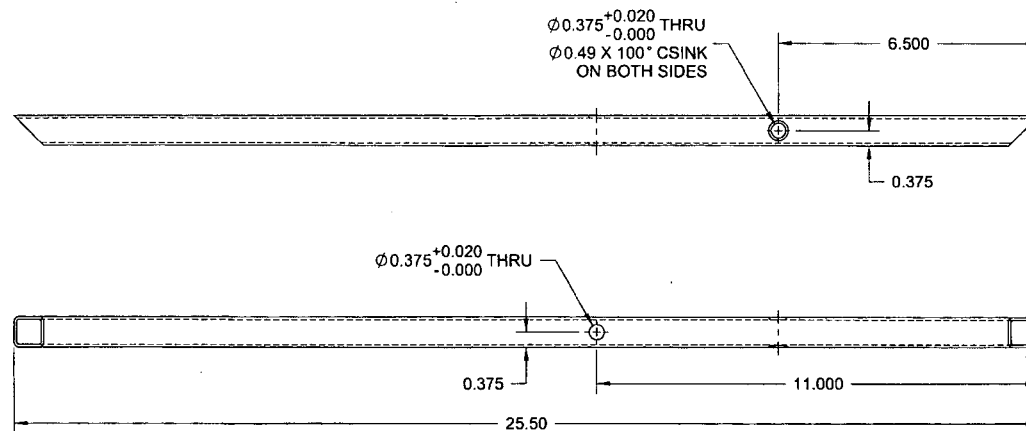
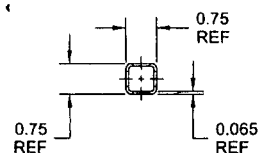


D3825-041 RIB ASSY (BASKET END)

RELEASED
08/11/18. NW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	M	D3825	SHEET 2 OF 3
APPROVED	WJ	TITLE	SCALE
DE APPR.	W	RIB ASSY (BASKET END)	NTS
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40.53644



D3825-1 RIB

RELEASED
08/11/13

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	08.09.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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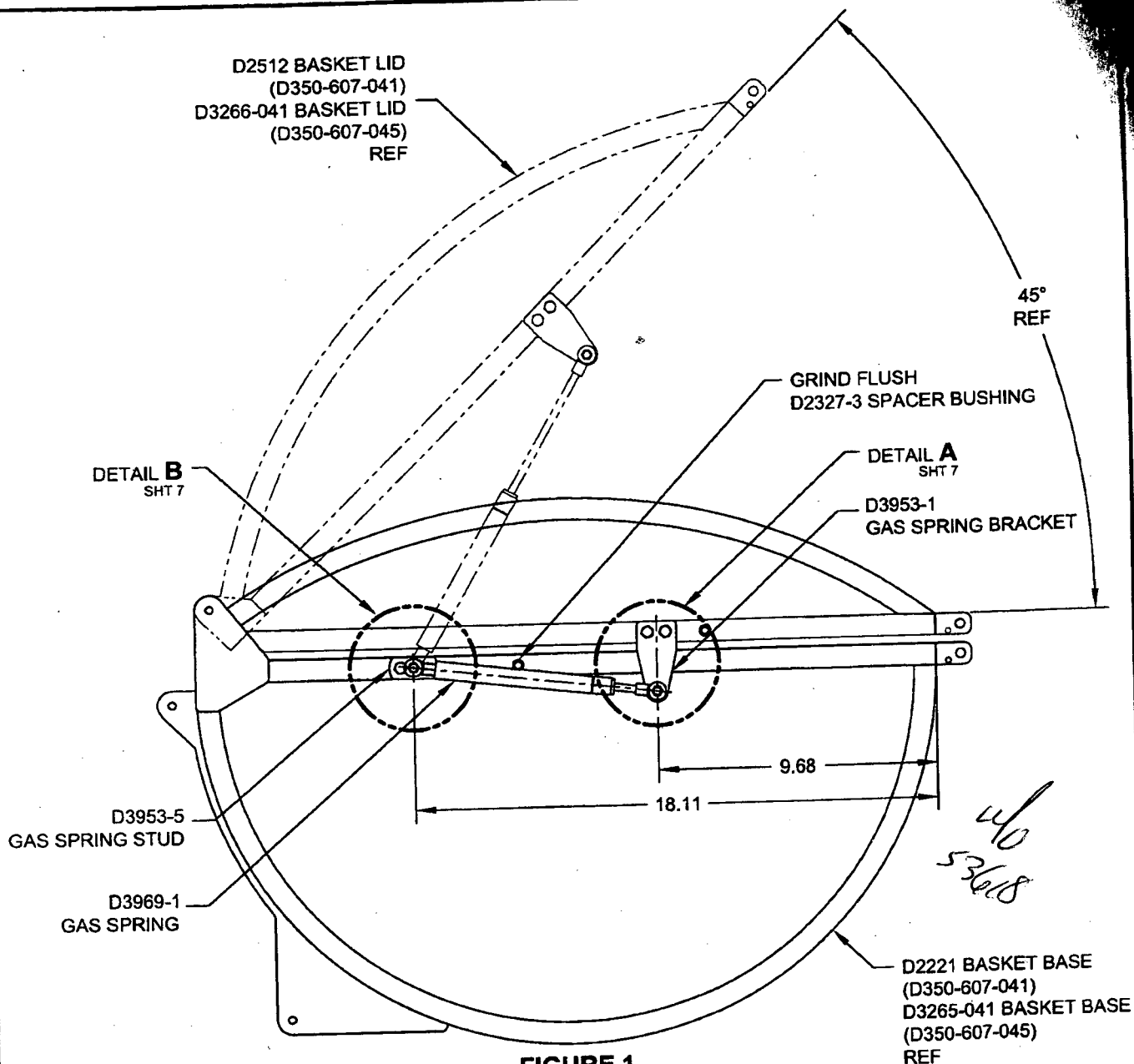


FIGURE 1

D350-607-141 GAS SPRING KIT INSTALLATION
(BOTH ENDS)

D350-607-145 GAS SPRING KIT INSTALLATION
(1 END ONLY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.09.15
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	AJS
DRAWN	AJS
CHECKED	<i>[Signature]</i>
MFG. APPR.	N/A
APPROVED	<i>[Signature]</i>
DE APPR.	<i>[Signature]</i>
DATE	09.09.15

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
DSI 9473 SHEET 5 OF 8
TITLE SCALE
GAS SPRING UPGRADE KIT NTS

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